

Work Order ID 125376

Tuesday, October 07, 2014 10:42:25 AM

125376

Page 1

Item ID: D3459-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Float Step Mounting Plate

Stop

NS2

Start Date: 10/06/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/06/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJDate: 1410-09

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3459	Rev A								
100		0.00							<u>DAS</u>
100	FLOW WATER JET								<u>23</u>
Waterjet	Memo	0.00							<u>9-89</u>
FLOW CNC Waterjet	1-Cut as per Dwg D3459								<u>14-11-14</u>
<i>6061.188 x 4"</i>	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							<u>DAS</u>
110	Memo	0.00							<u>23</u>
QC									<u>9-89</u>
Quality Control									<u>14-11-14</u>
120	QC8- Inspect parts - second check	0.00							<u>DAS</u>
120	Memo	0.00							<u>38</u>
QC									<u>9-89</u>
Quality Control									<u>NOV 14 2014</u>

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

<p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
---	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General							
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Other			

Work Order ID 125376

Tuesday, October 07, 2014 10:42:25 AM

125376

Page 2

Item ID: D3459-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Float Step Mounting Plate

Stop

NS2

Start Date: 10/06/14 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 10/06/14 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

130

130

Packaging

Packaging

Identify as per dwg & Stock Location: WA03

0.00

6X

06/14/11/17

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

14/11/17 JJ

DR-11-17

DQA: _____

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

<p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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Doc/Data									
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FAULT CATEGORY									
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other					

Picklist Print

Page 1

Tuesday, October 07, 2014 10:42:24 AM

Work Order ID: 125376

125376
D3459-1

Parent Item: D3459-1

Parent Item Name: Float Step Mounting Plate

Start Date: 10/06/14

Required Date: 10/06/14

Start Qty: 6.00

Required Qty: 6.00

Comments:	IPP Rev: A	New Issue	06-01-06	JLM
	IPP Rev: B	Waterjet	06-05-23	ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.187X04.00	Purchased	No		100	f	53.0168	0.347	(3)				
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0

DAS

23

9-89

14-11-14

M6061T6B0 187X04 000

6061-T6 Bar .187 x 4.00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT051	53.016842	
m128265	16.116842	128265
m129411	36.9	

DQA: _____

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

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Handling/Pre									
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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear			General						
	Bending		Bend		Folio/Program		Outside Dimensions		Pressure/Forced
	Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance		Set-up
	Cracks		Broken/Damage/Defect		Hardware		Part Incorrect		Temperature/Cure
	Crimp/Kink/Ripple/Wave		Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing		Weld
	Cuffs		Contamination		Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crushing		Countersink		Misaligned/off center		Positioned Wrong		
	Heat Treat		Cut Too Short		Mislabeled		Power Loss/Surge		
	Inspection Strip in Tube		Drawing		Misread				
	Marks/Chatter		Drill Holes		Off-set				
	Turning Sequence		Finish		Out of Calibration				
	Wave/Twist in Tube		Fit/Function		Out of Sequence				

DART AEROSPACE LTD	Work Order:	125376
Description: Float Step Mounting Plate	Part Number:	D3459-1
Inspection Dwg: D3459 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

DAS

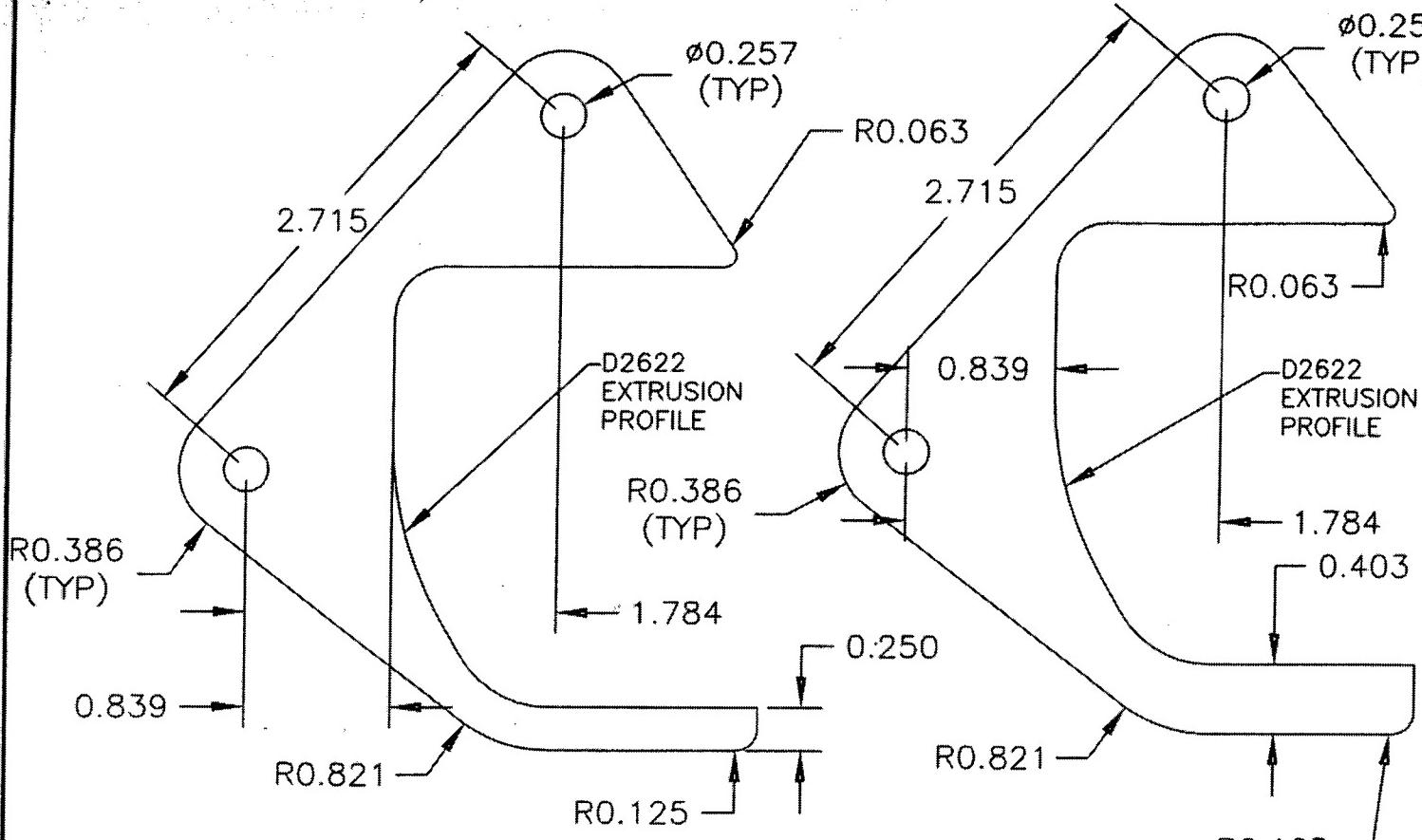
DAS

Measured by:	23 9-89	Audited by:	56 9-89	Prototype Approval:	N/A
Date:	14-11-14	Date:	NOV 14 2014	Date:	N/A

Rev	Date	Change	Revised by,	Approved
A	07.09.26	New Issue	KJ/EC/DD	E

DART

DESIGN <i>H</i>	DRAWN BY <i>H</i>	DART AEROSPACE USA, INC.		
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3459	PORT HADLOCK, WA	REV. A
DATE 05.09.23		TITLE FLOAT STEP MOUNTING PLATE		SHEET 1 OF 1
A	05.09.23	NEW ISSUE		SCALE 1:1



D3459-1 FLOAT STEP MOUNTING PLATE

D3459-3 FLOAT STEP MOUNTING PLATE

D3459-1/-3 FLOAT STEP MOUNTING PLATE

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK
(REF DART SPEC. M6061T6S.188)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 125376 MLS

14-10-09

RELEASED
05.11.14
CH